

Work Order ID **75246**

October-19-11 1:30:16 PM

*Rush Pass*

**\*75246\***

Page 1

Item ID: D3463-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Arm

Stop **\*NS2\***

Start Date: 19/10/2011 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 07/11/2011 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/10/11

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3463	Rev B

100

0.00

**\*100\***

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 25.00 " long

*B.A 11/10/21*

4 0

105

0.00

**\*105\***

Lathe Conv

Memo

0.00

Conventional Lathe

Ream tube at both ends aprox 2" deep at .750" Dia

*B.A 11/10/21*

4 0

110

0.00

**\*110\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Bend as per dwg D34632-Trim to lenght per dwg D34633- Deburr

*SB FF 12-01-10*

4 \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75246

**\*75246\***

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October-19-11 1:30:16 PM

Item ID: D3463-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Arm  
 Start Date: 19/10/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 07/11/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo Ensure 90 deg angle is within tol. (+/-0.5deg) critical dim.	0.00  0.00		826468		(44)			
130 <b>*130*</b> Mill Conv Conventional Milling Machine	CONVENTIONAL MILLING MACHINE  Memo 1- Drill as per dwg D3463(One side only) 2-Deburr as per dwg D3463	0.00  0.00		12/01/18		4			
140 <b>*140*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00		12/01/18		4			

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**NOTE:** Date & initial all entries

# Work Order ID 75246

October-19-11 1:30:16 PM

**\*75246\***

Page 3

Item ID: D3463-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Arm  
 Start Date: 19/10/2011 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 07/11/2011 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							
<b>*150*</b>									
QC	Memo	0.00				4	0		
Quality Control									
160	Identify as per dwg & Stock Location: <i>W/A</i>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

*12-01-19*  
*12-01-19*  
*12-01-19*

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

October-19-11 1:30:21 PM

Page 1

Work Order ID: 75246

**\*75246\***

Parent Item: D3463-1

**\*D3463-1\***

Parent Item Name: Arm

Start Date: 19/10/2011

Required Date: 07/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.17 NEW ISSUE EC  
ADDED MANUAL LATHE STEP 10-06-02 JLM VER:DD

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M316TR1.00W.120		Purchased	No			100	f	25.7500	2.083	8.770526			

**\*M316TR1.00W 120\***

**\*\***

316 RD tubing 1.00 x .120w

Location

Loc Qty

Loc Code

MAT018

17.8

✓ 118390

17.8

MAT037

7.95

✓ 111096

5.5

117890

2.45

4.1875<sup>++</sup>

4.1875<sup>++</sup>

J.A 11/10/21

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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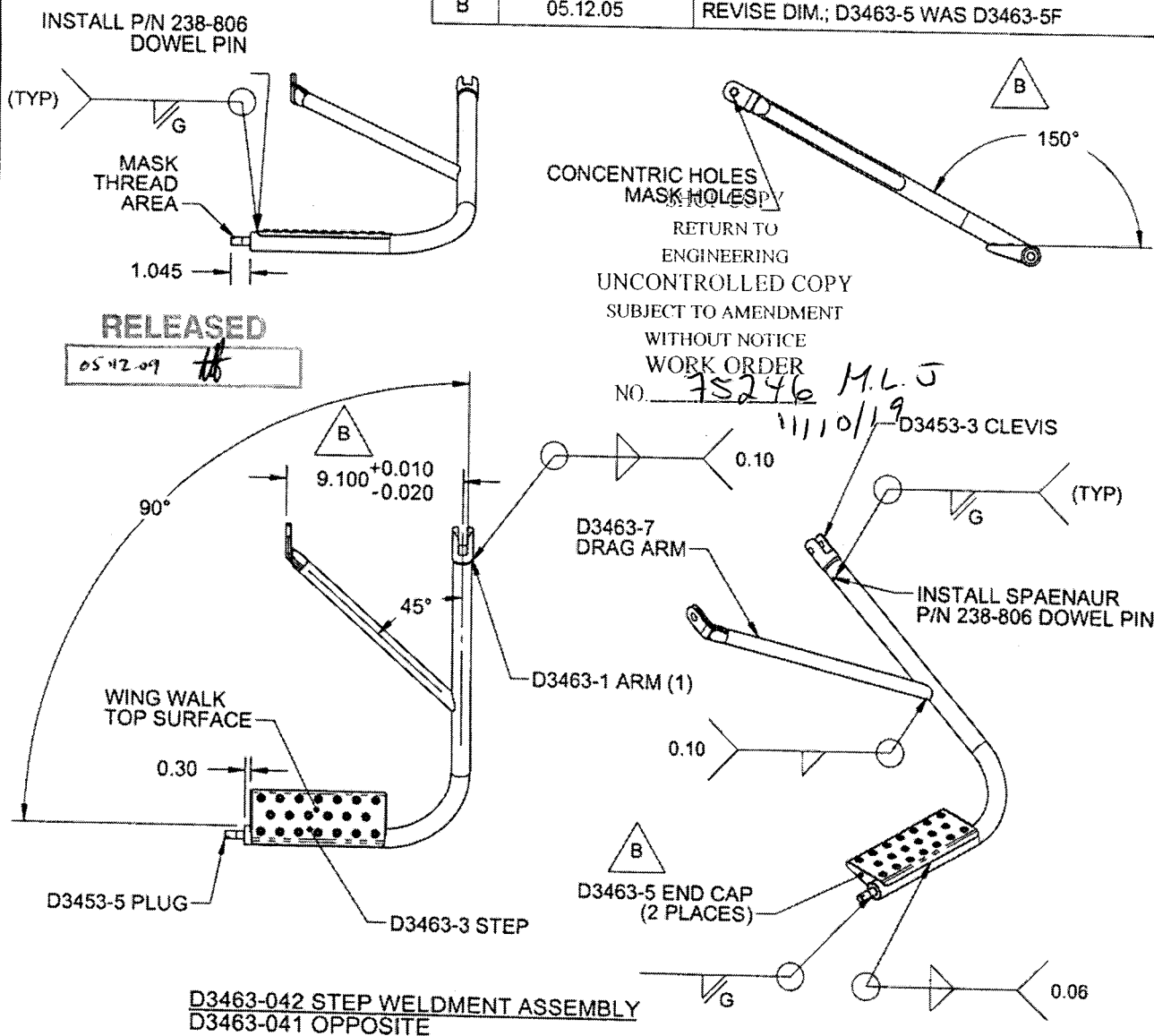
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3463</b>	REV. B SHEET 1 OF 4
DATE <b>05.12.05</b>		TITLE <b>STEP WELDMENT</b>	SCALE 1:8
A	05.09.20	NEW ISSUE	
B	05.12.05	REVISE DIM.; D3463-5 WAS D3463-5F	



**NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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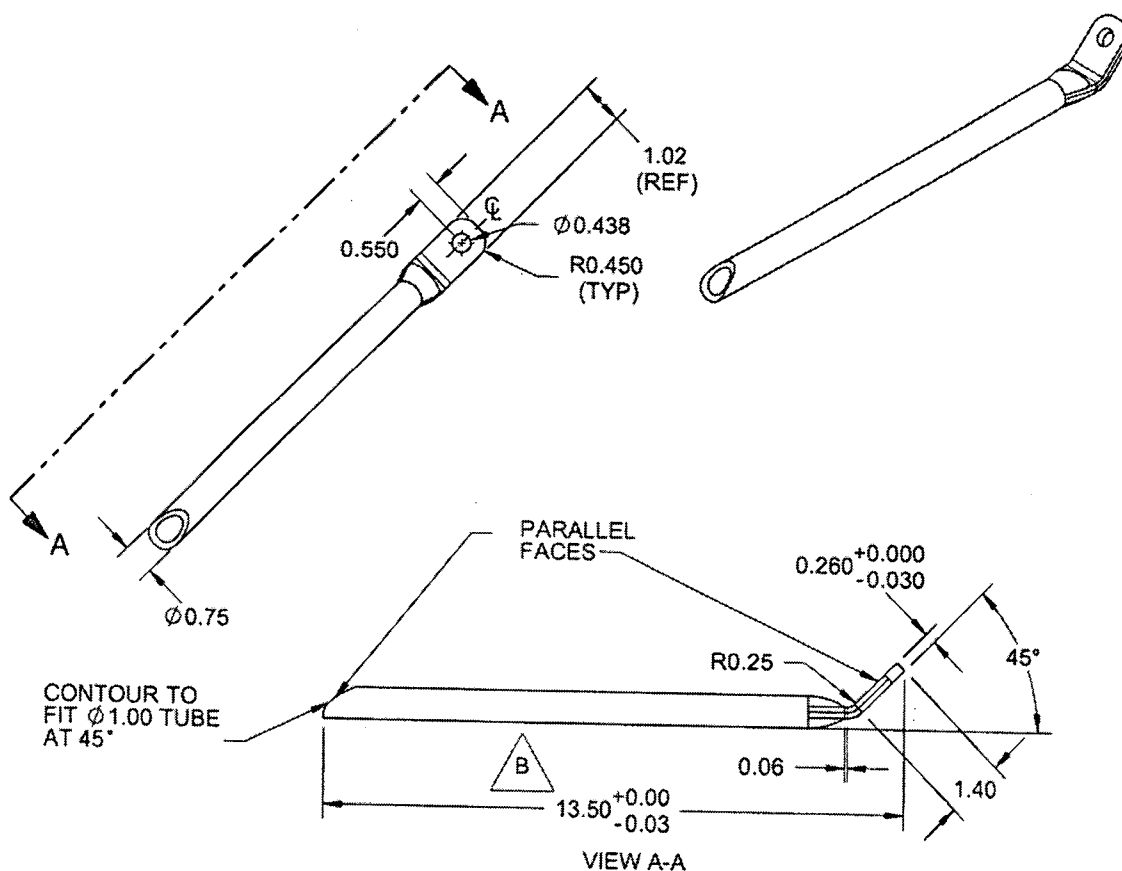
**NOTE:** Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:4

RELEASED

05.12.09 #



### D3463-7 DRAG ARM

#### NOTES:

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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test

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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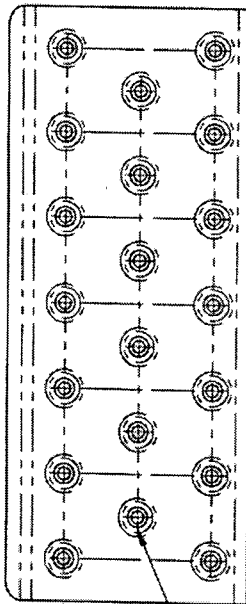
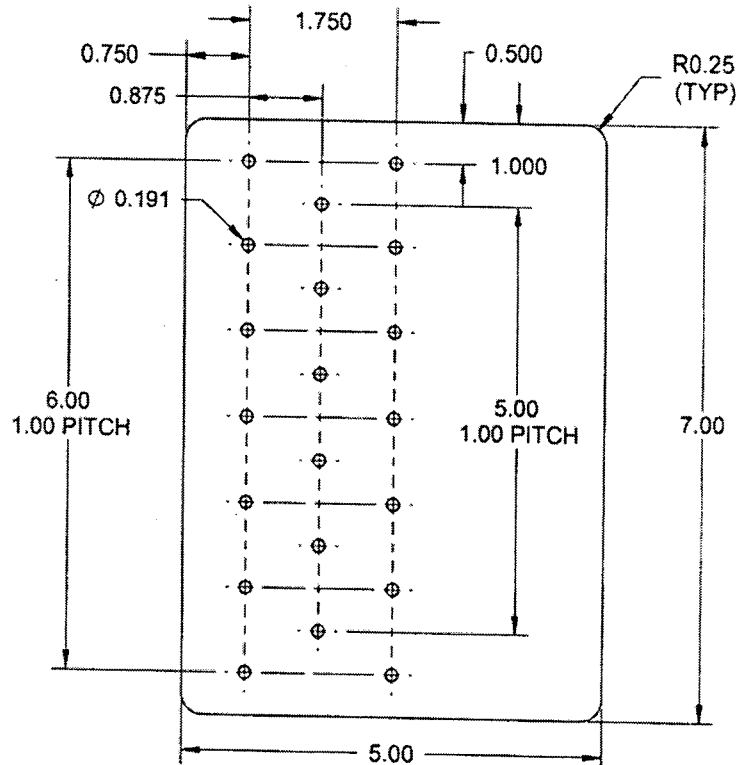
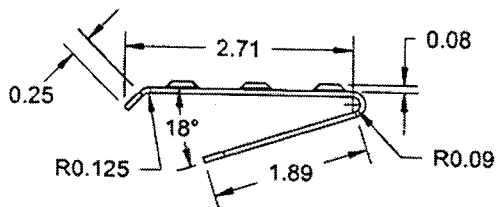
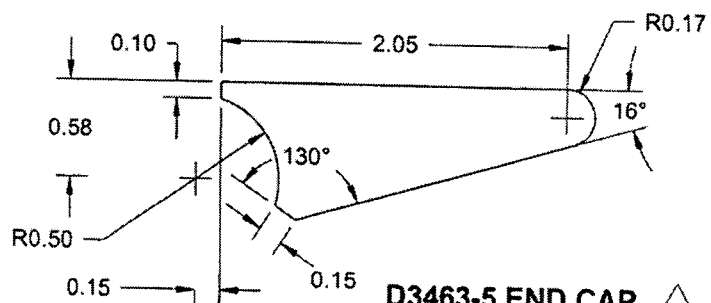


**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2

**RELEASED**

05.12.09 #

FORM USING  
D3463-3T1**D3463-3F FLAT PATTERN****D3463-3 STEP****D3463-5 END CAP**  
SCALE 1:1**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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75216

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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